










Date: Tuesday, 21/04/2009 4:01:03 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Job Number : 47342 Estimate Number : 11235 P.O. Number : This Issue : 21/04/2009 S.O. No. : Prsht Rev. : NC First Issue : / / Type : THERMOFORMING Previous Run : 46978	Drawing Name : FLOOR PROTCOR AFT RH Part Number : D32814 Drawing Number : D3281 REV. D Project Number : N/A Drawing Revision : D Material : Due Date : 30/04/2009 Qty: 10 Um: Each	
Written By : Checked & Approved By : <u>JULIE DAWSON</u>		
Comment : Est Rev:A 04.07.01 New issue KJ/JLM Est Rev B 07.08.07 Thermoform in house DL Ext. Rev C. 08.02.06 to reflect updated Dwg. DL Est. Rev D. 08.04.15 Material Change DL		
Additional Product		
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
1.0	MLEXS093F600602	GE PLASTICS LEXAN SHEET
 		
Comment: Qty.: 4.3330 sf(s)/Unit Total : 43.3300 sf(s) GE PLASTICS LEXAN SHEET Material Batch Number <u>M110877</u> <u>BB</u>		
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
 		
Comment: HAND FINISHING THERMOFORMING 1) Cut Blanks <u>BB</u> <u>09/04/22</u> <u>(X10)</u>		
3.0	THERMOFORMING	THERMOFORMING MACHINE
 		
Comment: THERMOFORMING MACHINE Thermoform as per Dwg. D32811and Folio FTA 010 Dwg. Rev. <u>D</u> Folio Rev. <u>B</u> <u>BB</u> <u>09/04/23</u> <u>(X10)</u>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>BB</u> <u>09/04/23</u> <u>(X10)</u>		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 21/04/2009 4:01:03 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR AFT RH

Job Number: 47342

Part Number: D32814

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 09/04/27 X10

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

BB 09/04/27 X10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/28 X10

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

9/4/28

10X
SD

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/28
MF 09-04-28

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47342
Description: Floor Protector, Aft RH		Part Number: D3281-4
Inspection Dwg: D3281 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB	Date: 09/04/23
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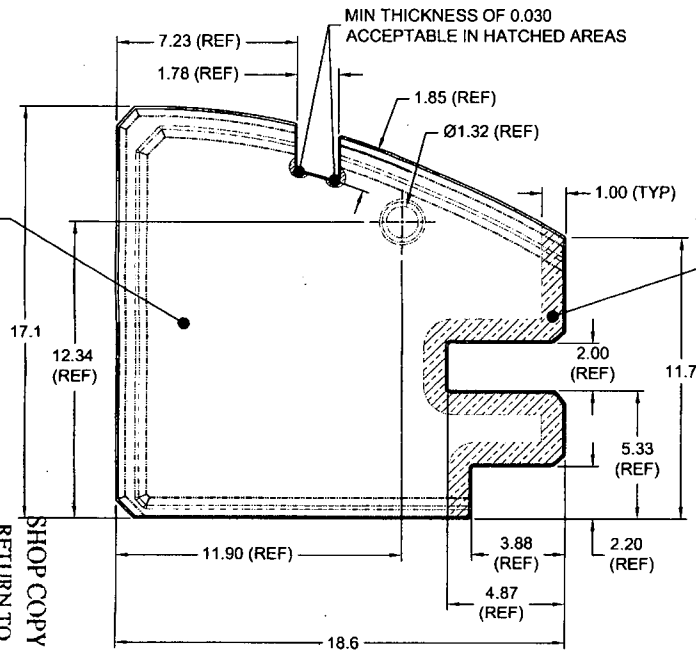
TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	+/-0.100	17.7	✓			
17.1	+/-0.100	17.05	✓			
14.3	+/-0.100	14.3	✓			
0.95	+/-0.030	.980	✓			
0.25	+/-0.030		N/A			
3.1	+/-0.100		N/A			
0.050	Min	.065	✓			
0.070	Min	.079	✓			

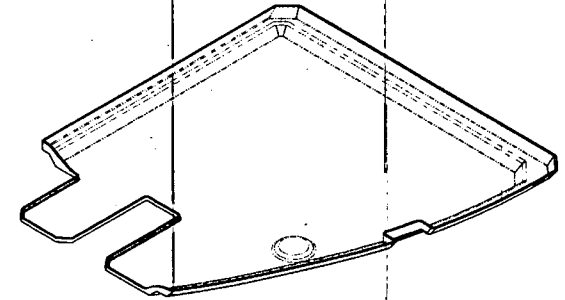
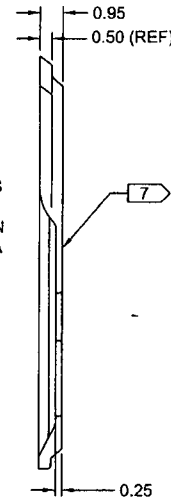
Measured by: BB	Date: 09/04/23
Audited by: WH	Date: 09/04/23
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	

TEXTURED SURFACE
ON THIS SIDE



MIN THICKNESS
OF 0.030
ACCEPTABLE IN
HATCHED AREA



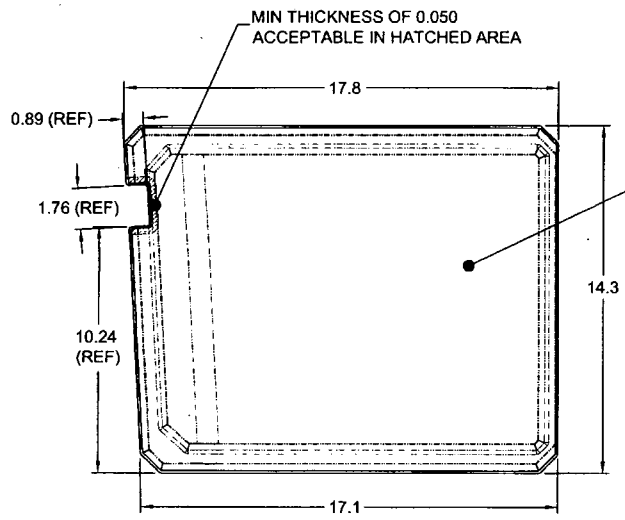
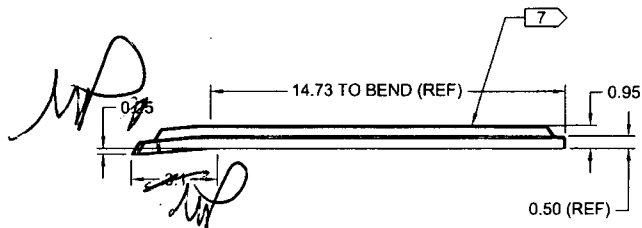
NO. 12345
WORK ORDER
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SUBJECT TO AMENDMENT

D3281-1 FLOOR PROTECTOR

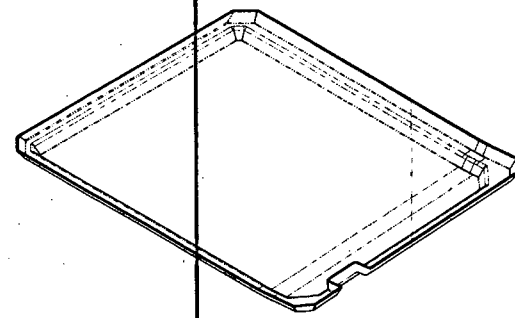
D3281-1 NOTES:

- 1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.95 lb

D	THICKNESS 0.093 WAS 0.125, MIN THICKNESS 0.070 WAS 0.080, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-4 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A8-1, A8-2, A8-3, A8-4)		PH	08.03.28	
C	UPDATE DIMS TO MATCH PARTS: COLOUR 701 WAS 700; GENERAL UPDATE		LE	07.10.09	
B	NOW LEXAN; DIMS AS MANUFACTURED		CP	05.11.25	
A	NEW ISSUE		CP	04.05.03	
REV.	DESCRIPTION		BY	DATE	
DESIGN	40	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	PH				
CHECKED	5				
MFG. APPR.	D3281				REV. D
APPROVED	TITLE				SHEET 1 OF 4
DE APPR.	FLOOR PROTECTOR				SCALE NTS
DATE	08.03.28	COPYRIGHT © 2004 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE BASIS OF A NON-REPRODUCTION AGREEMENT. IT IS NOT TO BE USED FOR ANY PURPOSE OR CONDUCT OR COMMUNICATED TO ANY OTHER PERSON OR FIRM WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>			



TEXTURED SURFACE
ON THIS SIDE



D3281-3 FLOOR PROTECTOR

D3281-3 NOTES:

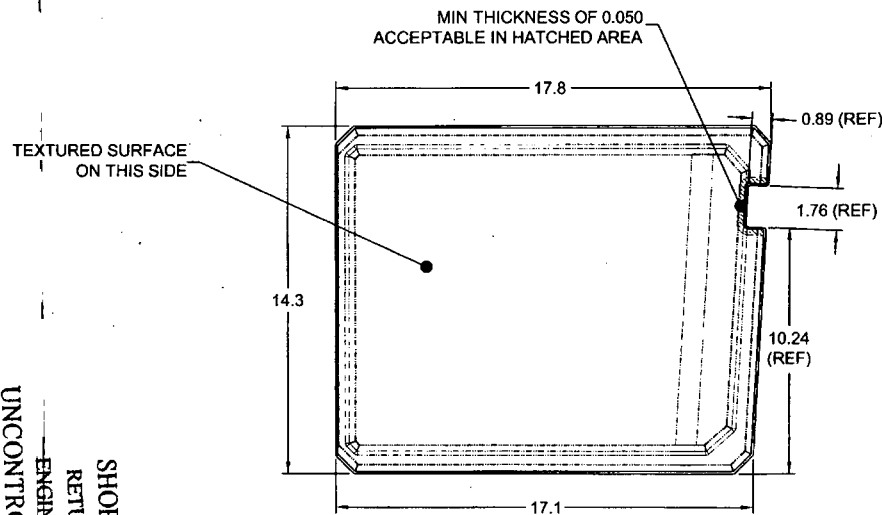
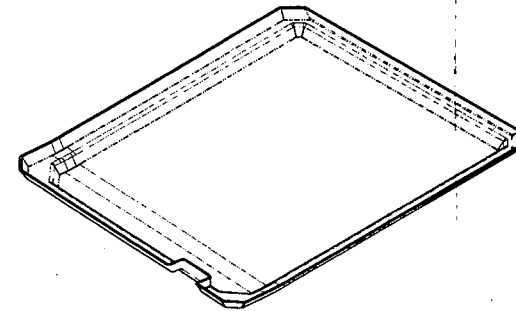
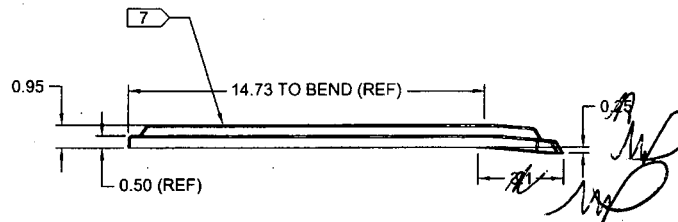
- 1) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb



DESIGN	92	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. D
MFG. APPR.	MD	D3281	SHEET 3 OF 4
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	FLOOR PROTECTOR	NTS
DATE	08.03.28	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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 WITHOUT NOTICE
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08-04-11 MP



D3281-4 FLOOR PROTECTOR

D3281-4 NOTES:

- 1) THERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-4" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	90	DART AEROSPACE LTD	
DRAWN	94	HAWKSWORTH, ONTARIO, CANADA	
CHECKED	94	DRAWING NO.	REV. D
MFG. APPR.	94	D3281	SHEET 4 OF 4
APPROVED	94	TITLE	SCALE
DE APPR.	94	FLOOR PROTECTOR	NTS
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